

303 750

Work Order ID 82874

April-10-12 2:34:49 PM

82874

Page 1

Item ID: D2570

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 10/04/2012 Start Qty: 400.00

400

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/04/10

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2570

Rev B

100

100

Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

0.00

SA/OK 12/05/05

409

Hardinge CNC Lathe Small

Machine as per folio FA258Deburr

110

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

SA/OK 12/05/05

409

Quality Control

120

120

QC

QC8- Inspect parts - second check

Memo

0.00

0.00

SL 12-05-09

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82874

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Page 2

Item ID: D2570

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bushing

Stop ***NS2***

Start Date: 10/04/2012 Start Qty: 400.00

400

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Identify as per dwg & Stock Location ST 11 0.00

130

Packaging

Memo

0.00

Packaging

4/09X

SP
12-5-9

140 QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/5/10

ML5 12/05/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-10-12 2:34:55 PM

Page 1

Work Order ID: 82874

82874

Parent Item: D2570

D2570

Parent Item Name: Bushing

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 400.00

Required Qty: 400.00

Comments: IPP E02.08.29Re-format; Removed finishing; Material changeKJ
IPP F 07.07.06 rev B dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R0.750

Purchased

No

100

f

212.5960

0.0771

32.46316

**

12/5/18

M303R0 750

303 Round Bar 0.750

Location

Loc Qty

Loc Code

MAT028

212.596

117328

13.242

117798

4.004

118509

4.08

119346

0.645

120145

10.566

121070

1.1

→ 121157

70.959

121282

108

30.4
2.21

12
12
6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

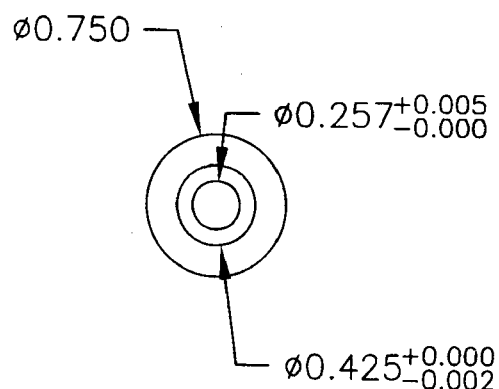
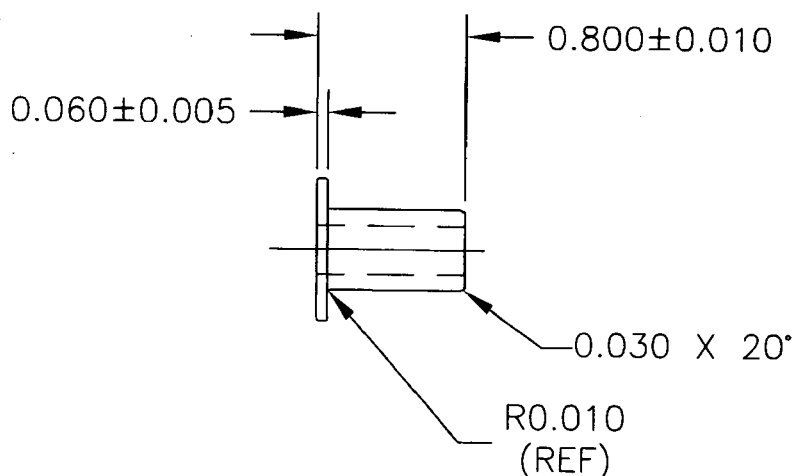
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2570	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	07.04.17	UPDATE NOTES	

RELEASED
07.06.28 H**D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82879 MLS
12/04/10

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